

Work Order ID 52521

September 29, 2009 10:48:31 AM



Page 1

Item ID: D3043-041
 Revision ID: A
 Item Name: Step Weldment LH, A119
 Start Date: 09/29/2009 Start Qty: 4.00
 Required Date: 10/10/2009 Req'd Qty: 4.00
 Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: [Signature] Date: 09-29 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3043 | Rev A |

| | | | | | | | | | |
|-----------|--|------|--|--|--|---|---|--|--|
| 100 | Large Fab | 0.00 | | | | 4 | 0 | | |
| Large Fab | Memo | 0.00 | | | | | | | |
| Large Fab | 1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G □2-Deburr and bevel ends for welding | | | | | | | | |

| | | | | | | | | | |
|-----------------|---|------|--|--|--|--|--|--|--|
| 110 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | 2) S or L w/5 | | | | | | | | |

| | | | | | | | | | |
|-----------|---|------|--|--|--|---|---|--|--|
| 120 | Large Fab | 0.00 | | | | 4 | 0 | | |
| Large Fab | Memo | 0.00 | | | | | | | |
| Large Fab | 1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8802 □AR AL ROD Batch: <u>1111311</u> □2-Grind Fwd End Cap weld flush | | | | | | | | |

1111494

09-10-13

September 29, 2009 10:48:31 AM

Page 2

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

[REDACTED]

QC

Quality Control

Memo

0.00

09.10.13

0.00



QC

Quality Control

Memo

0.00

27) $S_{09|10|12}$

49 LH

0.00

00000000000000000000

HandFinish

Hand Finishing

Memo

0.00

PK 09.10.12

4 0

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Item ID: D3043-041
Revision ID: A
Item Name: Step Weldment LH, A119

Accept



Setup Start



Stop



Start Date: 29/09/2009 Start Qty: 4.00

Cust Item ID:

Required Date: 16/10/2009 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 160 | Large Fab | 0.00 | | | | 4 | 0 | | |
| Large Fab | Memo | 0.00 | | | | | | | |
| Large Fab | 1-1-Weld 1 End Cap as per QSI 004 & Dwg D3043 AR ALROD Batch: <u>M111311</u> 2-Inspect for foreign object as per QSI024 3-Grind Fwd End Cap weld flush | | | | | | | | |
| 170 | QC9- Inspect visual per QSI004- Fusion Welds | 0.00 | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 180 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

09-10-15

PD 09.10.19 (4)

2) 09/10/17

2440

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| | | | | | | |
|----------------|------------------------|------------|------|---------------|-------|--|
| Item ID: | D3043-041 | Accept | | Setup | Start | |
| Revision ID: | A | | | | Stop | |
| Item Name: | Step Weldment LH, A119 | | | | | |
| Start Date: | 29/09/2009 | Start Qty: | 4.00 | Cust Item ID: | | |
| Required Date: | 16/10/2009 | Req'd Qty: | 4.00 | Customer: | | |

Reference:

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|-----------------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 190 HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 BR 09-10-19 0.00 | | | | (4) | | | |
| 200 QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 MD 09/10/19 0.00 | | | | XY | | | |
| 210 Powdercoat Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 1112 260 Memo START TIME: 12:00 320° FINISH TIME | 0.00 BR 09-10-19 0.00 | | | | (12) | | | |

OVEN TEMPERATURE:

12:30

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Item ID: D3043-041
Revision ID: A
Item Name: Step Weldment LH, A119

Accept



Setup Start



Stop



Start Date: 29/09/2009 Start Qty: 4.00
Required Date: 16/10/2009 Req'd Qty: 4.00



Cust Item ID:
Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 220 HandFinish Hand Finishing | Pressure Wash per QSI005 4.3 Wing walk as per QSI005 4.3 8/10/20 Memo | 0.00 0.00 | MD 09/10/20 | | | (4) | | | |
| 230 QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | MD 09/10/20 | | | (x4) | φ | | |
| 240 Packaging Packaging | Identify as per dwg & Stock Location: Memo | 0.00 0.00 | PDR 525B | | | 09/10/20 (4) | | | |

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Item ID: D3043-041
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Accept



Setup Start



Stop



Start Date: 29/09/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 16/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

250

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/21

mf

09-10-21

Picklist Print

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Page 1

Work Order ID: 52521

Parent Item: D3043-041RevA

Parent Item Name: Step Weldment LH, A119


Start Date: 29/09/2009

Required Date: 16/10/2009

Start Qty: 4.00

Required Qty: 4.00

Comments:

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3040-3RevB  Mounting Lug | | Manufactured | No | | | 100 | Each | 54.0000 | 8.0000 | | 09.10.02 | |

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

3

48241

3

Main Warehouse

WA

51

48240

51

= 8

120

Each

185.9200

4.0000

D2622-120CRevC1

Manufactured

No



Step Extrusion

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

185.92

48612 = 1

73.92

52026 = 3

112

120

Each

81.0000

8.0000

D2734RevC

Manufactured

No



Step End Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

81

43535

2

48110

79

4

09.10.13

Picklist Print

Page 2

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Work Order ID: 52521



Parent Item: D3043-041RevA



Parent Item Name: Step Weldment LH, A119



Start Date: 29/09/2009


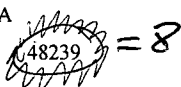
Required Date: 16/10/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|---|---------------|----------------|--------|
| D3040-1RevB  Mounting Lug | | Manufactured | No | | | 120 | Each | 56.0000 | 8.0000  | | 19.10.02 | |

| Warehouse | Loc Qty | Loc Code |
|--|---------|----------|
| Location | | |
| Main Warehouse | | |
| ST | 1 | |
|  | 1 | |
| Main Warehouse | | |
| WA | 55 | |
|  | 55 | |



| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3043 | REV. A SHEET 1 OF 2 |
| DATE 01.06.28 | | TITLE A119 STEP WELDMENT | SCALE NTS |
| A | 01.06.28 | NEW ISSUE | |

PARTS LIST:

| Qty -041 | Qty -043 | Part Number | Description |
|-------------|-------------|-------------|-------------------|
| X | | D3043-041 | STEP WELDMENT, LH |
| | X | D3043-042 | STEP WELDMENT, RH |
| | | | |
| 1 | 1 | D2622-120 | STEP EXTRUSION |
| 2 | 2 | D3040-1 | MOUNTING LUG |
| 2 | 2 | D3040-3 | MOUNTING LUG |
| 2 | 2 | D2734 | ENDPLATE |
| | | | |

NOTES:

- 1) MANUFACTURE FROM D2622-120 EXTRUSION
- 2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
- 3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52521

BP 09-9-29

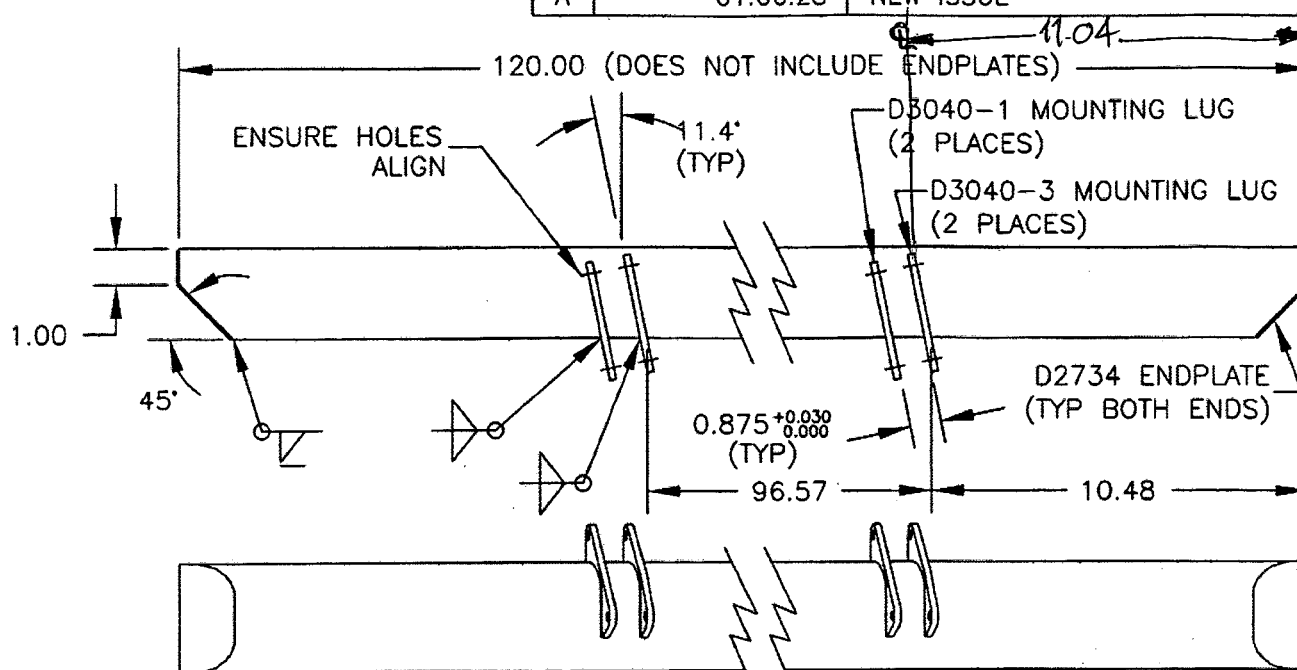
RELEASED
01.07.05 *[Signature]*

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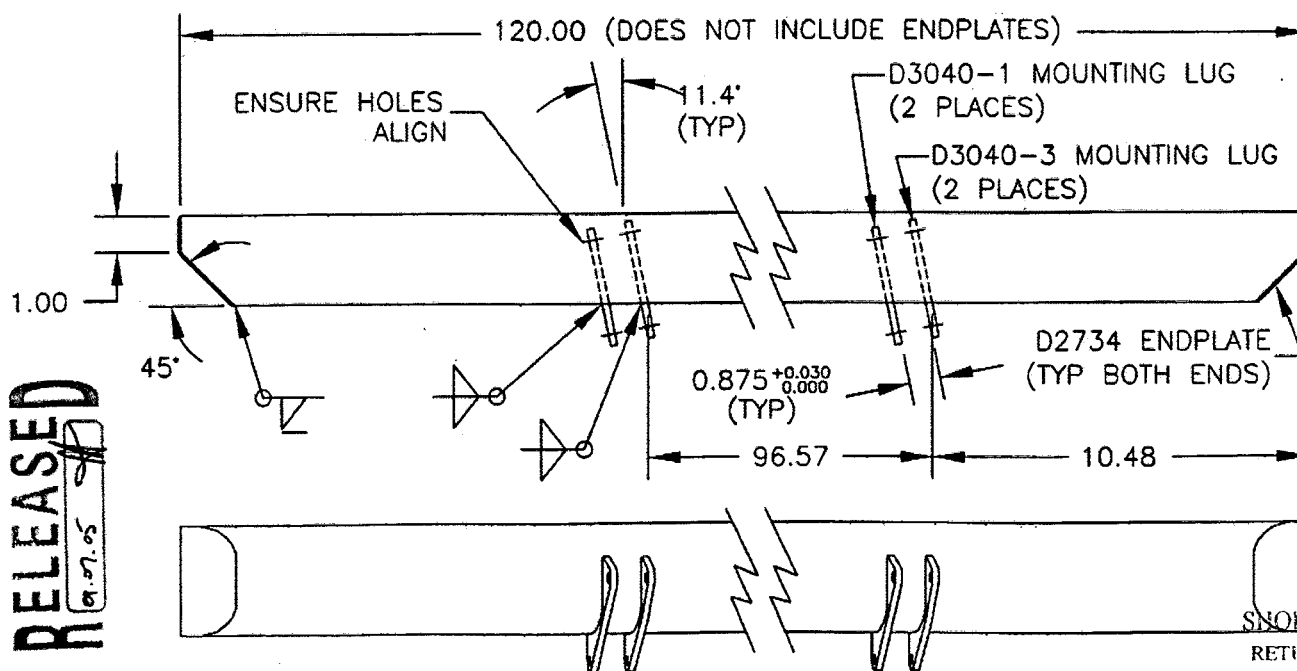
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| CHECKED <i>#</i> | APPROVED <i>#</i> | DRAWING NO. D3043 | REV. A SHEET 2 OF 2 |
| DATE 01.06.28 | | TITLE A119 STEP WELDMENT | SCALE 1:5 |
| A | 01.06.28 | NEW ISSUE | |



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 RH STEP WELDMENT

RELEASED
01.07.05SNOPIC
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ENGINEERING
UNCONTROLLED

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NO. 02521

09-925